



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5425-
Job Sheet 19625



Part No: D5425-043

Job Qty: 1 pcs

Part Name: Float Skidtube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/10/19

Job Tracking No:

Due Date: 7/30/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D5425 REV.B IPP REV.A 17.11.02 NEW ISSUE DD VERF:JFS IPP REV:B 18.08.20 AS PER DWG
REV.B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	7/30/19		0.00	8.24	Skidtubes - 1		TF
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	HAAS 4 Axis - B4B	1 pcs	7/30/19		1.00	22.77	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 2	1 pcs	7/30/19		0.00	0.00	QC 2 - 1		LT 19-07-19. RT 19-07-19.
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		



Container No: S193085

Part No: D5425 - 043

Job No: 196258

Lot No/Batch: S193085

Location: B

Operator:

Inspector:

Options: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/24/19

Plex 6/10/19 3:23 PM Dart.lajeunesse.marie

					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140 QC 8	1 pcs	7/30/19	0.00	0.00	QC 8 - 12	
					QC 8 - 14	OK 19/07/22
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
150 Handfinish - 1-1 Chemical-B4B	1 pcs	7/30/19	0.00	0.24	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	TF
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 -	

				B4B		
				Handfinish - 1 - 12 - B4B		
				Handfinish - 1 - 13 - B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
160 QC 7	1 pcs	7/30/19	0.00 0.00	QC 7 - 10		
				QC 7 - 13		
				QC 7 - 14		
				QC 7 - 15		
				QC 7 - 17		
				QC 7 - 18		
				QC 7 - 19		
				QC 7 - 2		
				QC 7 - 28		
				QC 7 - 3		
				QC 7 - 30		
				QC 7 - 34		
				QC 7 - 36		
				QC 7 - 37		
				QC 7 - 41		
				QC 7 - 47		
				QC 7 - 48		
				QC 7 - 51		
				QC 7 - 58		
				QC 7 - 59		
				QC 7 - 60	MAC	
				QC 7 - 9		
				QC 7 - 68		
				QC 7 - 50		
				QC 7 - 67		
				QC 7 - 40		
				QC 7 - 24		
				QC 7 - 43		
170 Skidtubes - Bend - 2 - B4B	1 pcs	7/30/19	0.50 2.63	Skidtubes - Bend - B4B	MAC	00
180 QC 5	1 pcs	7/30/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18	BE	
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
QC 5 - 3						

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						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
190 Skidtubes - 2 - B4B	1 pcs	7/30/19	0.00	8.24		Skidtubes - 1 - B4B	
						Skidtubes - 2 - B4B	
						Skidtubes - 3 - B4B	M/ra
						Skidtubes - 4 - B4B	
						Skidtubes - 5 - B4B	
						Skidtubes - 6 - B4B	
						Skidtubes - 7 - B4B	
200 QC 5	1 pcs	7/30/19	0.00	0.00		QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	DAS
						QC 5 - 68	AUG 28 2019 68
						QC 5 - 9	9-89
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
210 Handfinish - 6-1- Touch Up- B4B	1 pcs	7/30/19	0.00	0.24		Handfinish - 6 - 1 - B4B	
						Handfinish - 6 - 2 - B4B	
						Handfinish - 6 - 3 - B4B	AUG 29 2019
						Handfinish - 6 - 4 - B4B	
						Handfinish - 6 - 5 - B4B	
						Handfinish - 6 - 6 - B4B	
						Handfinish - 6 - 7 - B4B	
						Handfinish - 6 - 8 - B4B	
						Handfinish - 6 - 9 - B4B	
						Handfinish - 6 - 10 - B4B	
						Handfinish - 6 - 11 - B4B	
						Handfinish - 6 - 12 - B4B	
						Handfinish - 6 - 13 - B4B	
						Handfinish - 6 - 14 - B4B	
						Handfinish - 6 - 15 -	

				B4B	
				Handfinish - 6 - 16 - B4B	
				Handfinish - 6 - 17 - B4B	
				Handfinish - 6 - 18 - B4B	
				Handfinish - 6 - 19 - B4B	
				Handfinish - 6 - 20 - B4B	
				Handfinish - 6 - 21 - B4B	
				Handfinish - 6 - 22 - B4B	
220 QC 7	1 pcs	7/30/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	MGC
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
230 Skidtubes - 3 - B4B	1 pcs	7/30/19	0.00 8.24	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
240 QC 5	1 pcs	7/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
QC 5 - 49					

					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	SEP 05 2019 DAS 6.9
					QC 5 - 9	9.59
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
250 Handfinish - 6-2- Touch Up- B4B	1 pcs	7/30/19	0.00	0.33	Handfinish - 6 - 1 - B4B	
					Handfinish - 6 - 2 - B4B	
					Handfinish - 6 - 3 - B4B	SEP 06 2019
					Handfinish - 6 - 4 - B4B	
					Handfinish - 6 - 5 - B4B	
					Handfinish - 6 - 6 - B4B	
					Handfinish - 6 - 7 - B4B	
					Handfinish - 6 - 8 - B4B	
					Handfinish - 6 - 9 - B4B	
					Handfinish - 6 - 10 - B4B	
					Handfinish - 6 - 11 - B4B	
					Handfinish - 6 - 12 - B4B	
					Handfinish - 6 - 13 - B4B	
					Handfinish - 6 - 14 - B4B	
					Handfinish - 6 - 15 - B4B	
					Handfinish - 6 - 16 - B4B	
					Handfinish - 6 - 17 - B4B	
					Handfinish - 6 - 18 - B4B	
					Handfinish - 6 - 19 - B4B	
					Handfinish - 6 - 20 - B4B	
					Handfinish - 6 - 21 - B4B	
					Handfinish - 6 - 22 - B4B	
260 QC 7	1 pcs	7/30/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	

						QC 7 - 36	
						QC 7 - 37	
						QC 7 - 41	AB 17-9-9
						QC 7 - 47	
						QC 7 - 48	
						QC 7 - 51	
						QC 7 - 58	
						QC 7 - 59	
						QC 7 - 60	
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
270 Spray Paint - 2 - B4B	1 pcs	7/30/19	0.00	0.50		Spray Paint - 1 - B4B	AB 19-9-9
						Spray Paint - 2 - B4B	
						Spray Paint - 3 - B4B	
						Spray Paint - 4 - B4B	
280 QC 14	1 pcs	7/30/19	0.00	0.00		QC 14 - 15	
						QC 14 - 2	
						QC 14 - 34	
						QC 14 - 41	
						QC 14 - 51	
						QC 14 - 58	
						QC 14 - 59	BE 19-09-10
						QC 14 - 9	
						QC 14 - 68	
						QC 14 - 40	
						QC 14 - 19	
						QC 14 - 43	
						QC 14 - 24	
282 Outsource - 11 - Paint	1 pcs	7/30/19				ATE003-VC	2 N/R.
284 Packaging 2-1 - Receive - B4B	1 pcs	7/30/19	0.00	0.00		Packaging 2 - 1 - B4B	
						Packaging 2 - 2 - B4B	
						Packaging 2 - 3 - B4B	
						Packaging 2 - 5 - B4B	
						Packaging 2 - 4 - B4B	
						Packaging 2 - 6 - B4B	
						Packaging 2 - 7 - B4B	
						Packaging 2 - 8 - B4B	
						Packaging 2 - 9 - B4B	
						Packaging 2 - 10 - B4B	
						Packaging 2 - 11 - B4B	
						Packaging 2 - 12 - B4B	
						Packaging 2 - 13 - B4B	
						Packaging 2 - 14 - B4B	SEP 23 2019
						Packaging 2 - 15 - B4B	
						Packaging 2 - 16 - B4B	
						Packaging 2 - 17 - B4B	
						Packaging 2 - 18 - B4B	
						Packaging 2 - 19 - B4B	
						Packaging 2 - 20 - B4B	
						Packaging 2 - 21 - B4B	
						Packaging 2 - 22 - B4B	
						Packaging 2 - 23 - B4B	
						Packaging 2 - 24 - B4B	

Paint done
in house.
See q.# 270

DAS
70
9-89

DAS
59
9-89

286 QC 6	1 pcs	7/30/19	0.00	0.00	Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
290 Handfinish - 4-1-Assembly-B4B	1 pcs	7/30/19	0.00	0.24	Handfinish - 4 - 1 - B4B	
					Handfinish - 4 - 10 - B4B	BEB 19-09-10
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
300 QC 5	1 pcs	7/30/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	

QTY J041	P/N	DESCRIPTION
X	D5425-041	FLOAT SKIDTUBE ASSY
8	D3872-1	WASHER
1	D6425-1	FLOAT SKIDTUBE
1	D5485-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5512-1	CROSSBOLT SPACER
37	D5518-1	CROSSBOLT SPACER
6	AN805A	BOLT
6	NAS1148C032R	WASHER

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 196258 MJS

190671

D5425-041 FLOAT SKIDTUBE ASSY

RELEASED

2018 AUG 16

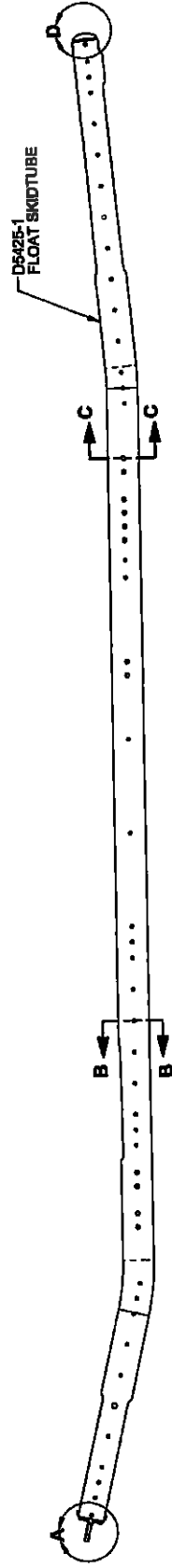
ECN 18-736

B	CHANGE HOLE SIZE TO IMPROVE OFF-AXIS SWAGING IN SHEETS 1 AND 6 (INCH 18-041), PICTORIAL UPDATE DUE TO CHANGES IN D5485-1.	NO	18.02.05
A	NEW ISSUE	NO	17.07.18
REV.	DESCRIPTION	BY	DATE
DESIGN	NO		
DRAWN	NO		
CHECKED	ZF		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	DS-1		
DATE	18.02.05		

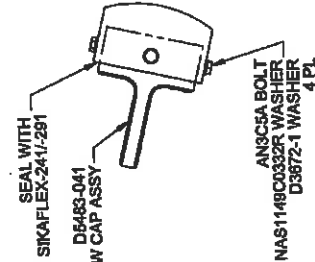
APPROVED

DART AEROSPACE USA, INC.		REV. 3
ELUGENE, OR		SHEET 1 OF 10
DRAWING NO.	D5425	SCALE
TITLE	412 FLOAT SKIDTUBE	NTS

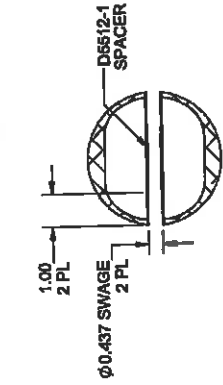
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D5425-041 FLOAT SKIDTUBE ASSY

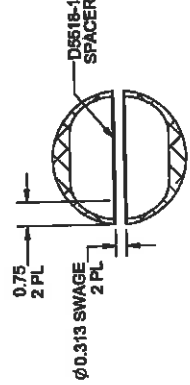


DETAIL A
SCALE 4X



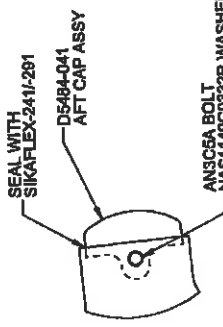
SECTION C-C
SCALE 4X
12 PL

AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR $\phi 0.608$ HOLES ONLY:
1. WET INSTALL D5612-1 SPACER PER QSI 002
2. SWAGE TO $\phi 0.437$ X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002



SECTION B-B
SCALE 4X
37 PL

AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR $\phi 0.377$ HOLES ONLY:
1. INSERT D5618-1 SPACER PER QSI 002
2. SWAGE TO $\phi 0.313$ X 0.75 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002



DETAIL D
SCALE 4X

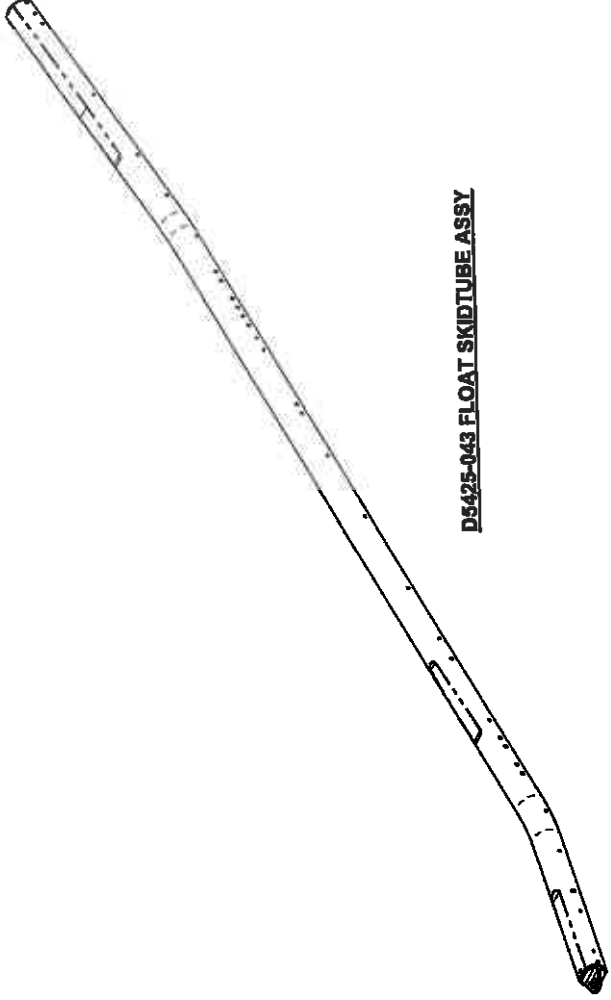
RELEASED
2018 AUG 16

- NOTES:**
1) MATERIAL: N/A
2) FINISH: PRIME PER DART QSI 005 4.2.1, 3.3
PAINT PER DART QSI 018 UNLESS OTHERWISE NOTED
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 64.3000
8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCVON"

DESIGN	NO	NO	DART AEROSPACE USA, INC.
DRAWN			ELBENE, OR
CHECKED		ZF	DRAWING NO. D5425
INFG. APPR.		DD	REV. B SHEET 2 OF 10
APPROVED		NO	TITLE
DE APPR.		DS	412 FLOAT SKIDTUBE
DATE	18.02.05		SCALE NTS

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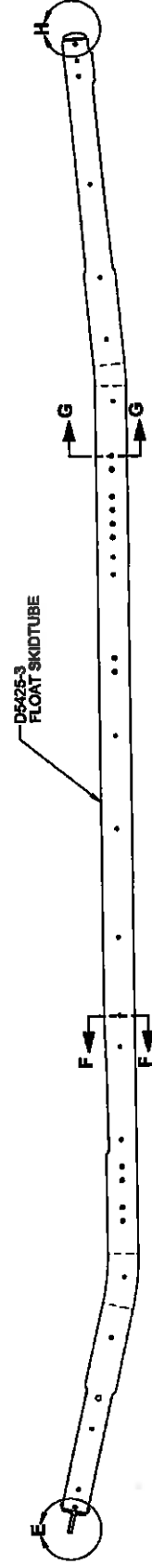
QTY -X-	PIN	DESCRIPTION
X	D5425-043	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D5425-3	FLOAT SKIDTUBE (DART TRIBAG)
1	D5485-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5512-1	CROSSBOLT SPACER
18	D5518-1	CROSSBOLT SPACER
6	AN9C5A	BOLT
6	NAS149C032R	WASHER



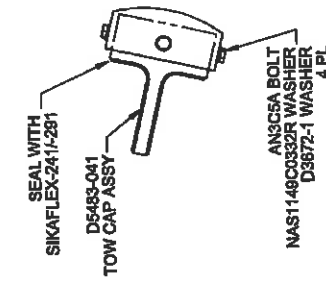
D5425-043 FLOAT SKIDTUBE ASSY

RELEASED
2018 AUG 16

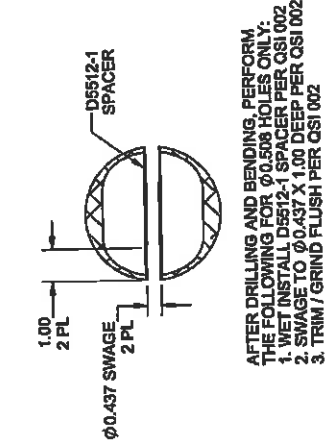
DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DO	D5425	SHEET 3 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	D5425	412 FLOAT SKIDTUBE	NTS
DATE	18.02.05	COMPONENT IS NOT BY DART AEROSPACE USA, INC. THIS DRAWING IS THE PROPERTY OF DART AEROSPACE USA, INC. IT IS TO BE USED FOR THE PURPOSE OF MANUFACTURING THE PARTS AND ASSEMBLIES ONLY. NO OTHER USES ARE PERMITTED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	



D5425-043 FLOAT SKIDTUBE ASSY

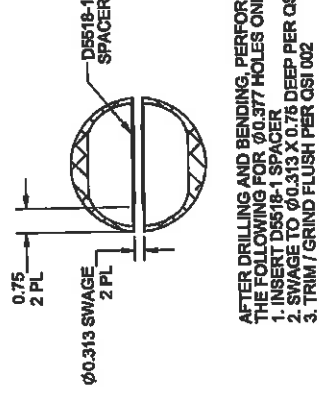


DETAIL E
SCALE 4X



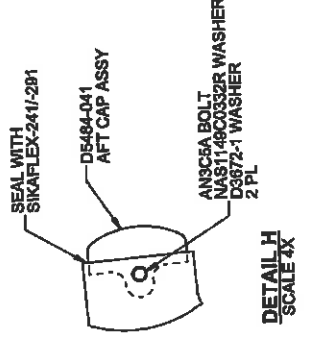
SECTION G-G
SCALE 4X
12 PL

AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. WET INSTALL D5512-1 SPACER PER QSI 002
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002



SECTION F-F
SCALE 4X
18 PL

AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.377 HOLES ONLY:
1. INSERT D5518-1 SPACER
2. SWAGE TO Ø0.313 X 0.75 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002



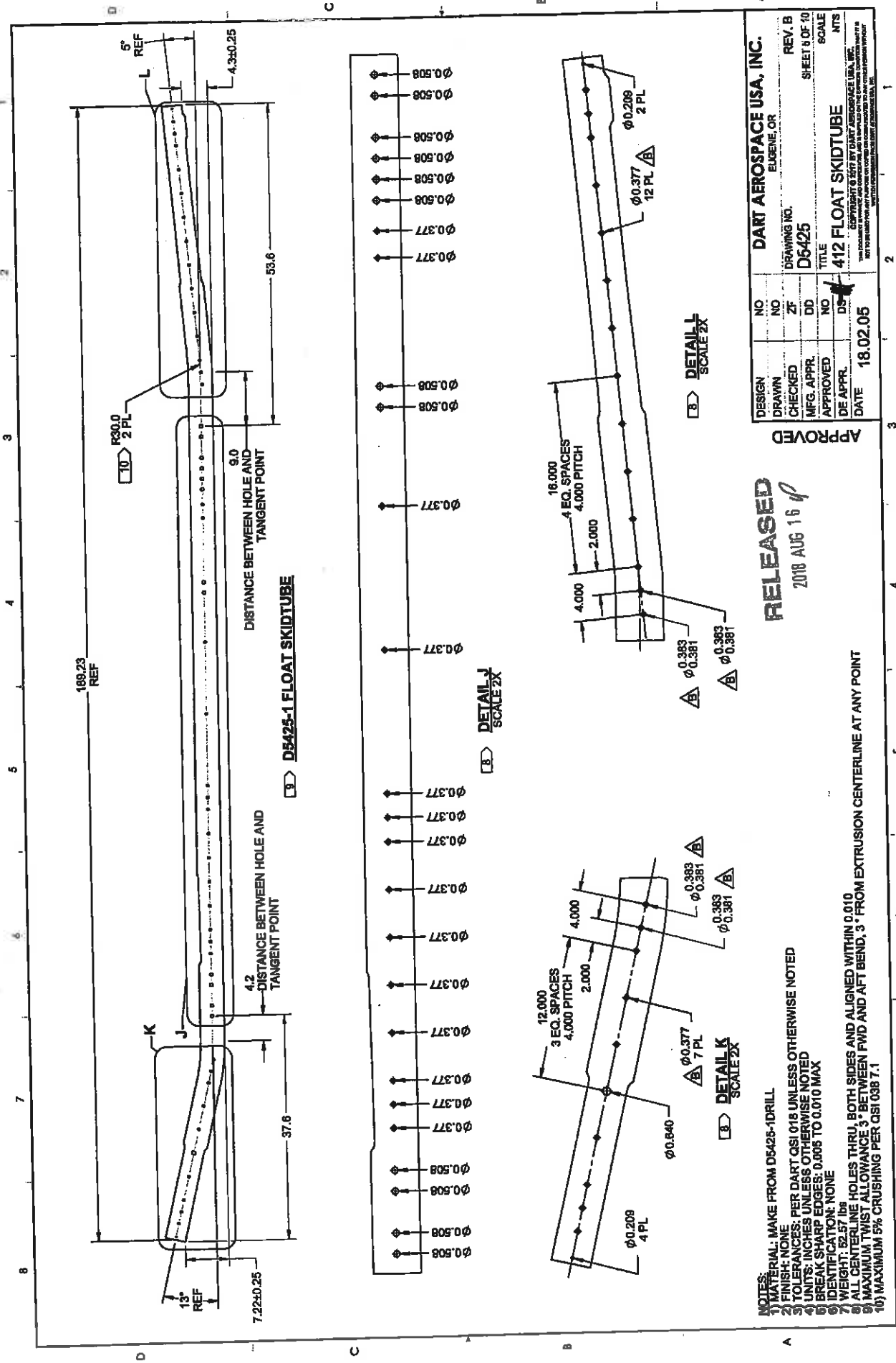
DETAIL H
SCALE 4X

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2018 AUG 16 *40*

- NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3
PAINT PER DART QSI 005 4.2.2.4
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES N/A
6) IDENTIFICATION: IDENTIFY PER QSI 044 8.1
7) WEIGHT: 54.3lbs
8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCOYON"

DESIGN		NO		DART AEROSPACE USA, INC.	
DRAWN	CHECKED	NO	NO	EUGENE OR	
MFG. APPR.	DE APPR.	ZF	DD	DRAWING NO.	REV. B
				D5425	SHEET 4 OF 10
				TITLE	SCALE
				412 FLOAT SKIDTUBE	MTS
				DATE	18.02.05

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NOTES:
1) MATERIAL: MAKE FROM D5428-1DRILL
2) FINISH: NONANCE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK: RADIUS: 0.005 TO 0.010 MAX
6) BREAK: LOCATION: NONE
7) WEIGHT: 62.57 lbs
8) ALL CENTERLINE HOLES THRU, BOTH SIDES AND ALIGNED WITH CENTERLINE
9) MAXIMUM TWIST ALLOWANCE 3" BETWEEN FWD AND AFT BEN
10) MAXIMUM 5% CRUSHING PER QSI 038 7.1

NOTES:
 1) MATERIAL: MAKE FROM D5428-1DRILL
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 0418 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK: CHAMFER: 0.005 TO 0.010 MAX
 6) BREAK: RADIATION: NONE
 7) WEIGHT: 52.57 lbs
 8) ALL CENTERLINE HOLES THRU, BOTH SIDES AND ALIGNED WITHIN 0.010
 9) MAXIMUM TWIST ALLOWANCE: 3" BETWEEN FWD AND AFT BEND, 3" FROM EXTRUSION CENTERLINE AT ANY POINT
 10) MAXIMUM 5% CRUSHING PER QSI 038 7.1

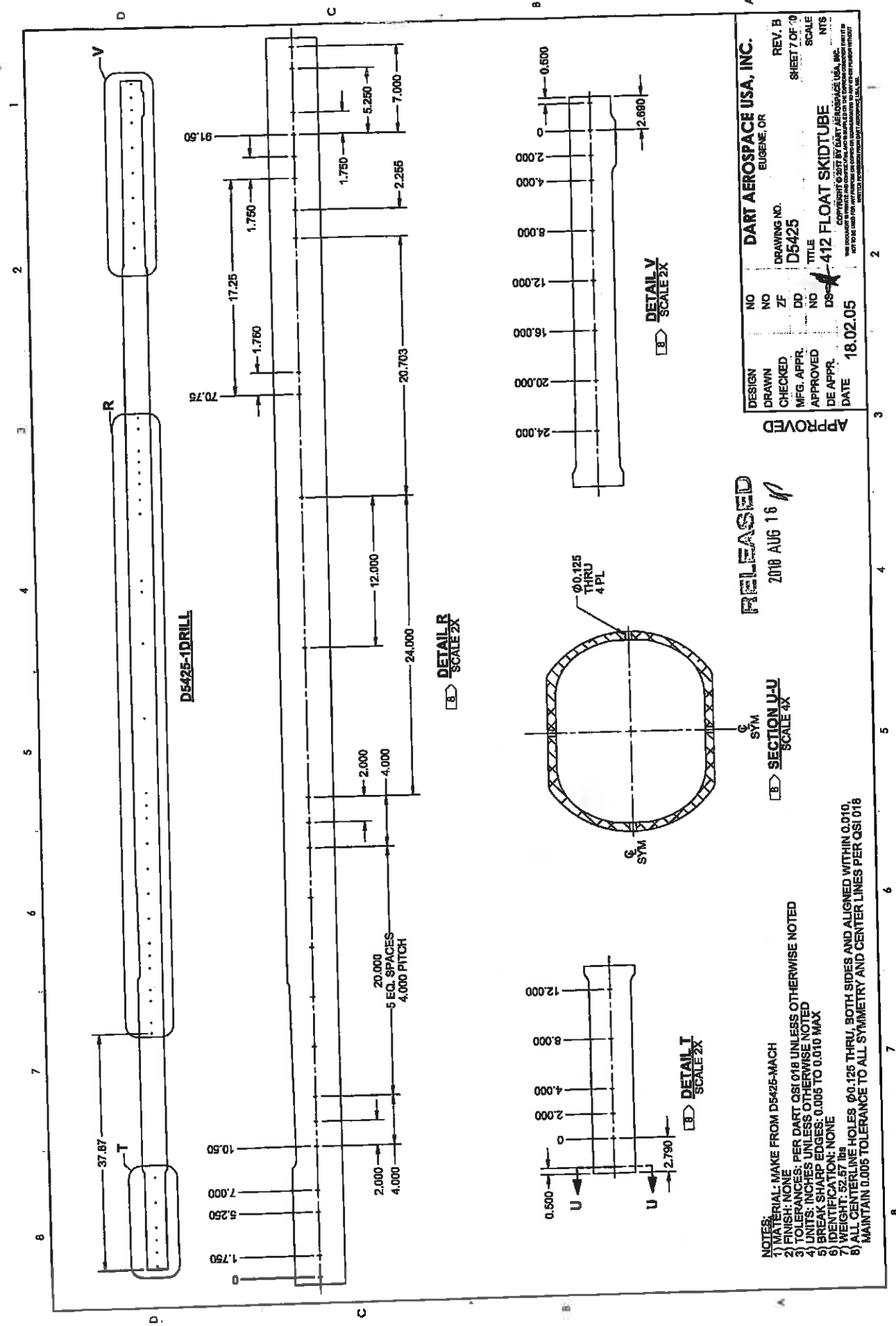
RELEASED
2018 AUG 16

APPROVED

DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR DRAWING NO. D5425 TITLE 412 FLOAT SKIDTUBE SHEET 1 OF 10 REV. B SCALE NTS COPYRIGHT © 1977 BY DART AEROSPACE USA, INC. ALL RIGHTS RESERVED. NO PART OF THIS PUBLICATION MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.
DRAWN	NO	
CHECKED	2F	
MFG. APRR	DD	
APPROVED	DD	
DE APRR.	DS	
DATE	18.02.05	

FOR VETERANALLY SERVICING PROFESSIONALS

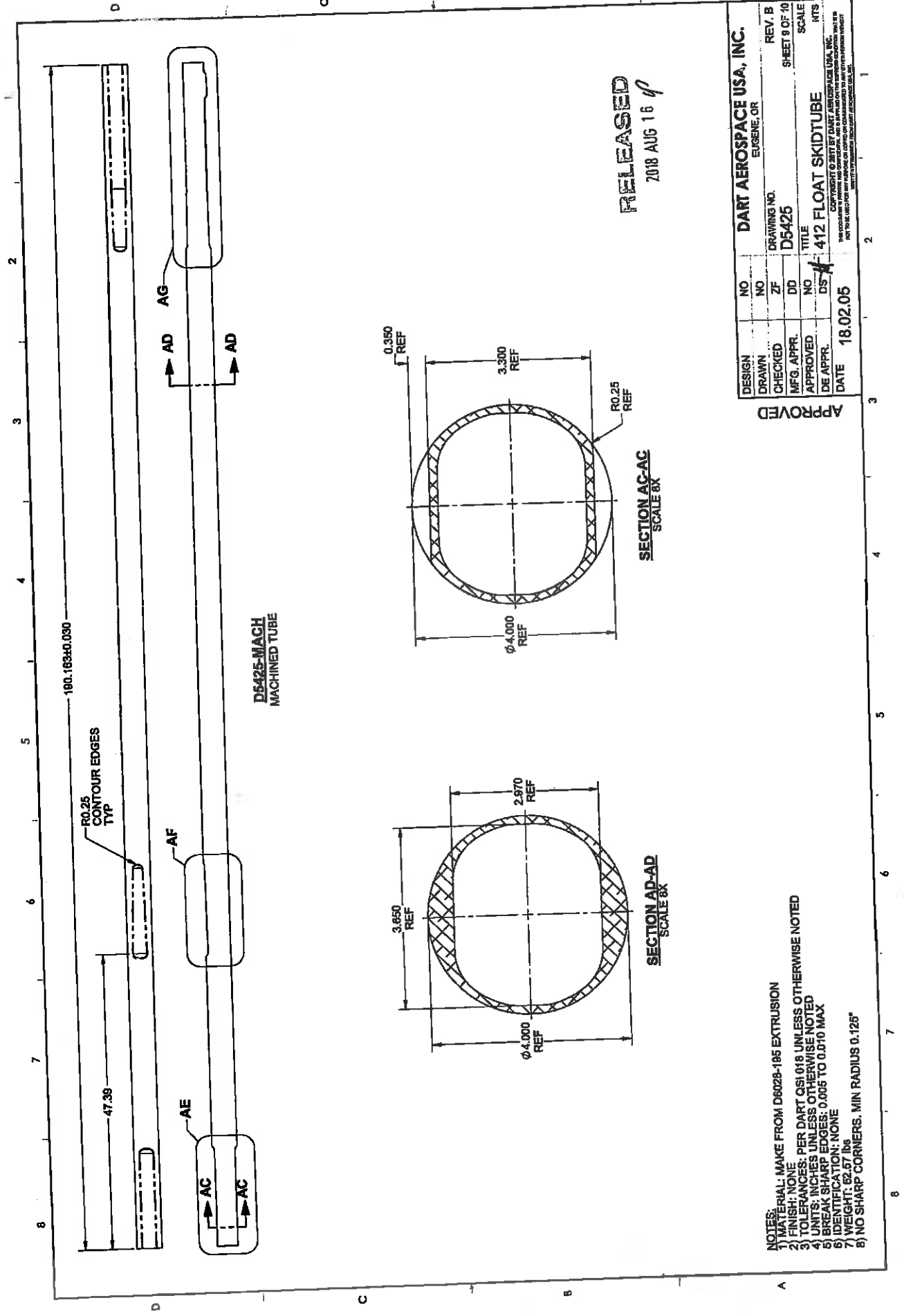
FOR VETERANALLY SERVICING PROFESSIONALS



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2018 AUG 16

SECTION U-U
SCALE 4X

NOTES:
1) MATERIAL: MAKE FROM D5425-MACH
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 52.57 lbs
8) ALL CENTERLINE HOLES Ø0.125 THRU, BOTH SIDES AND ALIGN
MAINTAIN 0.005 TOLERANCE TO ALL SYMMETRY AND CENTER



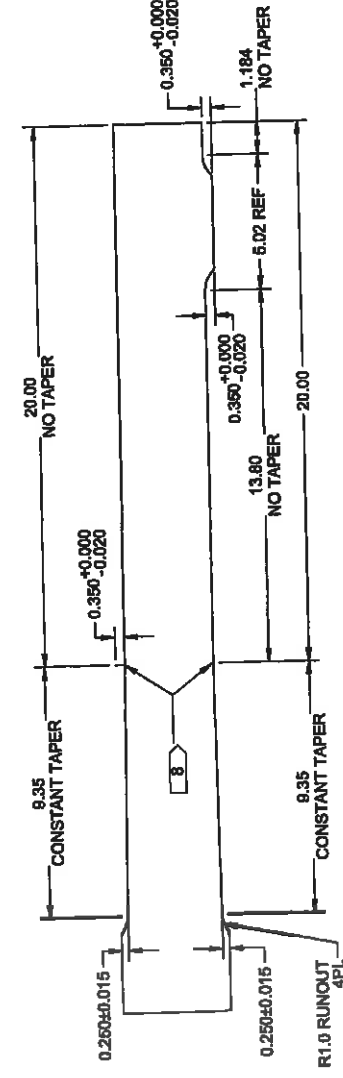
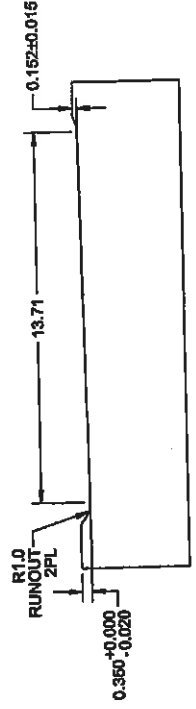
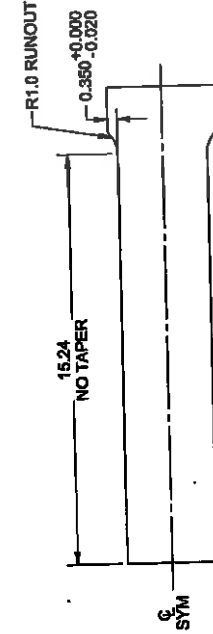
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2018 AUG 16 40

SECTION AC-AC
SCALE 8X

SECTION AD-AD
SCALE 8X

- NOTES:
- 1) MATERIAL: MAKE FROM D6028-185 EXTRUSION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 62.67 lbs
 - 8) NO SHARP CORNERS. MIN RADIUS 0.125"

DESIGN	NO	NO	DART AEROSPACE USA, INC.
DRAWN	CHECKED	ZF	EUGENE, OR
MFG. APPR.	DE APPR.	DD	D5425
APPROVED	DATE	DS	18.02.05
REV. B	SHEET 9 OF 10	SCALE	412 FLOAT SKIDTUBE
ATS			



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2018 AUG 16 4P

DART AEROSPACE USA, INC. EUGENE, OR			
DESIGN	NO	NO	REV. 3
DRAWN	CHECKED	ZF	DRAWING NO. D5425
MFG. APPR.	DD	NO	SHEET 10 OF 10
APPROVED	NO	NO	SCALE
DE APPR.	DATE	18.02.05	412 FLOAT SKIDTUBE
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DART AEROSPACE LTD		Work Order: 196258
Description: 412 Float Kidtube		Part Number: D8425-043
Inspection Dwg: D5425 Rev: B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/- .010	0.500	✓		Kt-05	Verm
2.790	+/- .010	2.790	✓		ind dial	HAAS 4.
10.790	+/- .010	10.790	✓		"	"
14.790	+/- .010	14.790	✓		"	"
43.120	+/- .010	43.126	✓		tape	REF
44.870	+/- .010	44.870	✓		"	"
48.37	+/- .010	48.37	✓		"	"
60.37	+/- .010	60.37	✓		"	"
64.37	+/- .010	64.37	✓		"	"
74.37	+/- .010	74.37	✓		"	"
123.328	+/- .010	123.328	✓		"	"
125.87	+/- .010	125.87	✓		"	"
129.37	+/- .010	129.37	✓		"	"
131.12	+/- .010	131.12	✓		"	"
134.62	+/- .010	134.62	✓		"	"
136.37	+/- .010	136.37	✓		"	"
0.500	+/- .010	0.500	✓		Kt-05	Verm
2.690	+/- .010	2.690	✓		"	"
4.69	+/- .010	4.69	✓		dial ind	HAAS 4.
18.69	+/- .010	18.69	✓		"	"
15.24	+/- .020	15.24	✓		"	"
21.0	+/- .100	1.00	✓		R-6	REF
0.350	+0.000 / - .020	0.340	✓		dial ind	HAAS 4
0.350	+0.000 / - .020	0.340	✓		"	"
21.0	+/- .100	1.000	✓		R-6	REF
13.71	+/- .020	13.71	✓		dial ind	HAAS 4
0.152	+/- .015	0.150	✓		"	"
0.250	+/- .015	0.238	✓		"	"
9.35	+/- .030	9.35	✓		"	"
0.350	+0.000 / - .020	0.340	✓		"	"
20.00	+/- .030	20.00	✓		"	"
0.250	+/- .015	0.240	✓		"	"

Measured by: Kt	Checked by: JKL	QC Inspector:
Date: 19-07-19	Date: 19/07/22	Date:

Engineering Approval: (if necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

